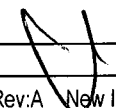
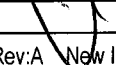


Ship Jense 13/12

Dart Aerospace Ltd.



Date: Tuesday, 11/12/2007 7:04:19 AM  
User: Linda Lacelle

### Process Sheet



<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW KIT (19"X24")
<b>Job Number</b> : 36246	
<b>Estimate Number</b> : 12617	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D315670011
<b>This Issue</b> : 11/12/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2432 REV F3
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : F3
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 14/12/2007 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est Rev:A New Issue 07-01-03 JLM	



#### Additional Product

Job Number: 

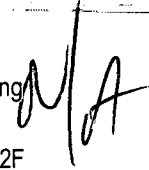
Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		 K-8 07.12.11 (2)

**Comment:** DOCUMENT CONTROL  
Photocopy bluefile and create labels per PPP D315-670-011 CHG001

2.0	MUHMWB10	UHMW 1" Black
	 2	 4
<b>Comment:</b> Qty.: 6.8250 sf(s)/Unit Total : 13.6500 sf(s) blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 made on w/o 32785 Material: Black UHMW 1" (MUHMWB10) Batch: 2x D2432 B 32785		



3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		

**Comment:** HAAS CNC VERTICAL MACHINING #1  
Note: (2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining 

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/12/2007 7:04:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 36246

Part Number: D315670011

Job Number:



Seq. #:

Machine Or Operations

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 5.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch  
6 D2182B050 Rubber Cushion

34777

6 p/s 3" 2/12/12 (2)

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
12 D2274 Radius Block  
2 D2432F(ref only) Bearpaw

B32015

32785

2/12/12 (2)

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
6 D2438 Clamp

33937

2/12/12 (2)

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
12 D2529 Washer

32025

2/12/12 (2)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 5/11/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE** Initial all entries

Date: Tuesday, 11/12/2007 7:04:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 36246

Part Number: D315670011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

*M103691*

12.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

*M105426*

13.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

*M105054*

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD315-670-011

Location:

*ONAPT*

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 07/12/12*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries